

of expansion, so that when the stud *B*, which is turned to fit the tapered hole in the bushing, is screwed down, the bushing is expanded.

Locating by Keyways in the Work. — Sometimes the work to be finished in the jig is provided with a keyway or a slot, or with some other kind of a seat, by means of which it is located on its component part on the machine for which it is ultimately in-

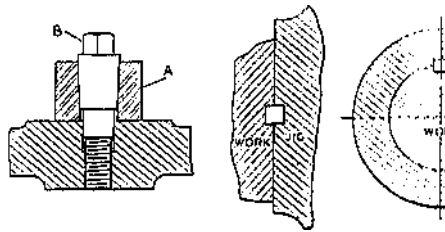
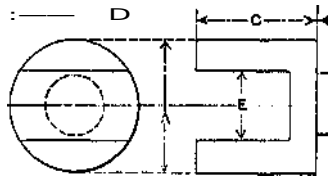


Fig. 24. **Fig. 25.** **Fig. 26.**

tended, and it is always essential that the work be located in the same way in the jig as it is to be located on the machine on which it is to go; thus, if the work has a keyway suitable for locating, a corresponding keyway ought to be put into the jig, and the work located by means of a key, as shown in Figs,



**Fig. 27. Work which
is Milled as Indicated
at E**

25 and 26. Instead of a loose key, a tongue may be planed

or milled solid with the jig, but, as a rule, it is more satisfactory to have the loose key, as, if it should happen to wear, it is possible to replace it; and if the width of the keyway should vary in different lots of the parts made, it is possible, with little expense, to make a new key to fit the variation, whereas if the key is made solid with the jig, and found to be either too large or too small, the trouble of fixing this would be considerably greater.